

## WHAT IS CLAIMED IS:

1. A closed battery comprising:  
an electrode element consisting of a positive electrode, a negative electrode, and a separator;  
an electrolyte;  
a battery container accommodating said electrode element together with said electrolyte; and  
a closing member fitted in the inner periphery of an open end portion of said battery container to close the open end portion of the battery container;  
wherein said closing member consists of a metal substrate, a valve element which is provided in said metal substrate and defined by a break line so as to serve as a releasing chip such that when the internal pressure of the battery is elevated, the valve element is bent from a bending fulcrum which does not have a break line so as to provide the metal substrate with an opening portion for releasing the internal pressure, and a metal foil which is adhered to the inner surface of said metal substrate.
2. The closed battery according to claim 1 wherein said metal foil is connected to a lead member for conducting a current from said electrode element to a closing cap, and when said valve element operates to release internal pressure in the battery, said lead member is electrolytically disconnected from the metal foil to interrupt the current.
3. The closed battery according to claim 1 wherein

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said valve element has a substantially circular form, a part of which is a bending fulcrum portion.

4. The close battery according to claim 1 wherein said valve element has a substantially tongue-like form.

5. The closed battery according to claim 1 wherein said metal substrate is made of a material selected from the group consisting of steel sheet, stainless steel sheet, copper sheet, and aluminum sheet.

6. The closed battery according to claim 1 wherein said metal foil is made of a material selected from the group consisting of steel foil, stainless steel foil, copper foil, aluminum foil, nickel foil, and nickel-iron alloy foil.

7. The closed battery according to claim 1 wherein said break line penetrates the entire thickness of said metal substrate.

8. The closed battery according to claim 1 wherein said valve element has a substantially horseshoe form.

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